

Date: Thursday, 4/12/2007 9:33:29 AM
 User: Kim Johnston

Process Sheet

| | |
|--|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : HINGE BRACKET, GAS SPRING |
| Job Number : 31782 | |
| Estimate Number : 10179 | |
| P.O. Number : <i>N/A</i> | Part Number : D2144 |
| This Issue : 4/12/2007 S.O. No. : <i>N/A</i> | Drawing Number : D2144 REV. D |
| Prsht Rev. : NC | Project Number : <i>N/A</i> |
| First Issue : <i>N/A</i> Type : SMALL /MED FAB | Drawing Revision : D |
| Previous Run : 28949 | Material : <i>N/A</i> |
| Written By : _____ | Due Date : 5/10/2007 Qty: 20 Um: Each |
| Checked & Approved By : <i>07.04.12</i> | |
| Comment : Est: D 04.05.06 Reformat KJ/RF | |
| Est Rev:E Now on Waterjet 06-10-15 JLM | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|-----------|--------------------|
| 1.0 | M304S16GA | 304/316 .063 Sheet |
|-----|-----------|--------------------|



Comment: Qty.: 0.0945 sf(s)/Unit Total : 1.8900 sf(s)

304/316 .063 Sheet 16GA

Batch: *M19052*

SAD 07/05/08

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET

1-Cut as per Dwg D2144

Dwg Rev: *2*

Prog Rev: *2*

2-Deburr if necessary

SAD 07/05/08

20

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/05/08

20

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

SG 07.05.08

20

| | | |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

ml 07/05/09

X 20

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 9:33:29 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET, GAS SPRING

Job Number: 31782

Part Number: D2144

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2144 Rev: D

SB 07/05/23 (20)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/05/23 (20)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FAB RESOURCE 1

1- Weld corner as per Dwg D2144 & QSI 004
2- Grind flush

FC 07 05 23 (20)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/05/29 (20)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/05/29 (20)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M103141

BR/M-L 07/05/29 (20)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

CU

7/5/30 SG

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SB 210

6 7/5/30 SG (20)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/05/30

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 9:33:29 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET, GAS SPRING

Job Number: 31782

Part Number: D2144

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

D0765/30

Job Completion



Le D0765/30

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

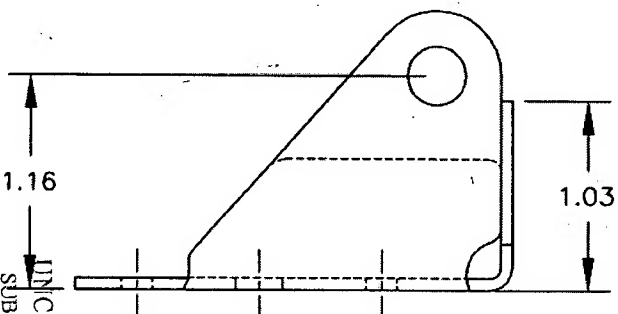
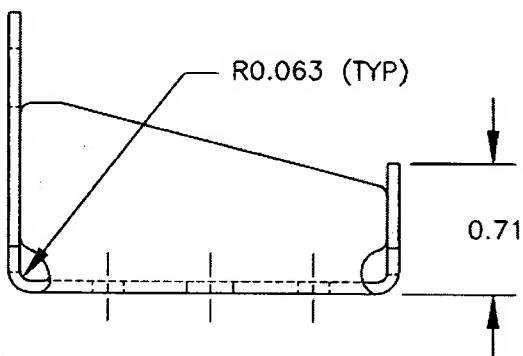
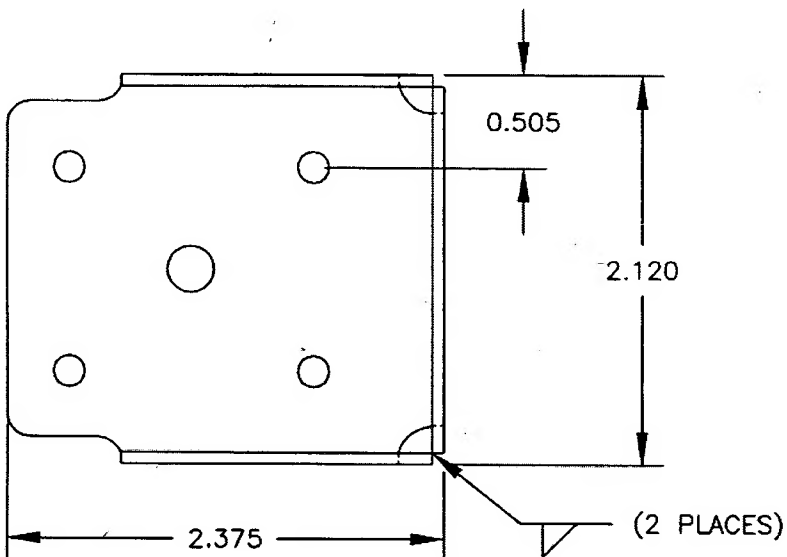
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



RELEASED
98.10.15 KE

| | | | | |
|---------|----------|------------------------------------|---------------|---|
| DESIGN | bu | DRAWN BY | KE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED | MA | APPROVED | KE | REV. D |
| DATE | 98.10.08 | TITLE | HINGE BRACKET | SHEET 1 OF 2 |
| | | | | SCALE 1:1 |
| A | 95.03.17 | NEW ISSUE | | |
| C | 96.06.05 | FLAT PATTERN LAYOUT ADDED | | |
| D | 98.10.08 | UPDATED DIMS AFTER BEND (TSR A917) | | |



FINISH: POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
WELD PER DART QSI 004

UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE

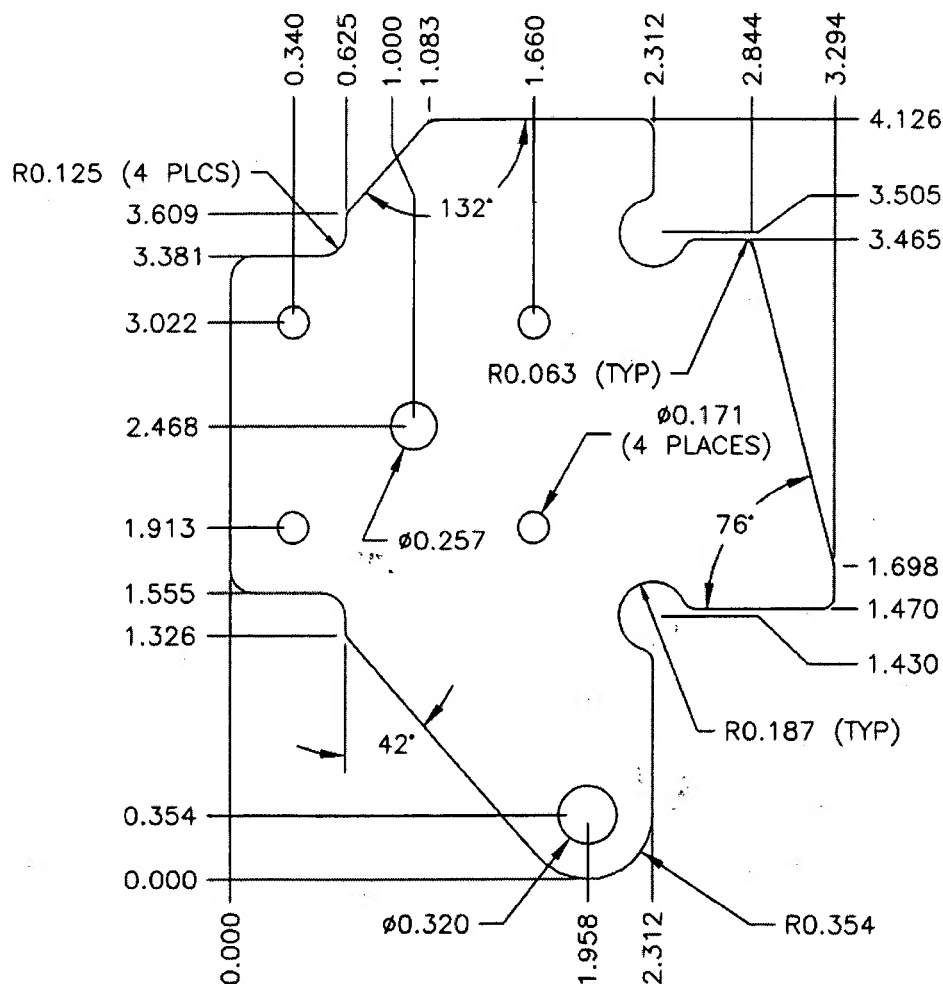
WORK ORDER

NO. 31782



| | | | |
|------------------------|-------------------------|---|------------------------|
| DESIGN BW | DRAWN BY KE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D2144 | REV. D SHEET 2 OF 2 |
| DATE 98.10.08 | TITLE HINGE BRACKET | | SCALE 1:1 |

RELEASED
98.10.15 KE



D2144 FLAT PATTERN

MATERIAL: AISI 304/316-2B SS, 0.063 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31.782

| | | |
|------------------------------|--|--------------------|
| DART AEROSPACE LTD | | Work Order: 31782 |
| Description: Hinge Bracket | | Part Number: D2144 |
| Inspection Dwg: D2144 Rev: 1 | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Inspection Sheet Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---------------------------------------|------------------|---------------------|--------|--------|-------------------------|----------|
| A 3.381 | +/- 0.010 | 3.385 | ✓ | | height gauge | |
| B 3.022 | +/- 0.010 | 3.016 | ✓ | | height gauge | |
| C 2.468 | +/- 0.010 | 2.466 | ✓ | | height gauge | |
| D 1.913 | +/- 0.010 | 1.910 | ✓ | | height gauge/vern | |
| E 1.555 | +/- 0.010 | 1.550 | ✓ | | height gauge | |
| F 4.126 | +/- 0.010 | 4.130 | ✓ | | Vern | |
| G 3.465 | +/- 0.010 | 3.460 | ✓ | | height gauge | |
| H 0.340 | +/- 0.010 | 0.346 | ✓ | | height gauge | |
| I 0.625 | +/- 0.010 | 0.619 | ✓ | | height gauge | |
| J 1.000 | +/- 0.010 | 0.997 | ✓ | | Vern | |
| K 1.083 | +/- 0.010 | 1.082 | ✓ | | height gauge | |
| L 1.660 | +/- 0.010 | 1.660 | ✓ | | Vern | |
| M 2.312 | +/- 0.010 | 2.318 | ✓ | | height gauge | |
| N 2.844 | +/- 0.010 | 2.850 | ✓ | | Vern | |
| O 3.294 | +/- 0.010 | 3.298 | ✓ | | Vern | |
| P Ø 0.257 | +0.006 -0.001 | Ø 0.258 | ✓ | | Vern | |
| Q Ø 0.171 | +0.003 -0.001 | Ø 0.173 | ✓ | | Vern | |
| R Ø 0.320 | +0.008 -0.001 | Ø 0.320 | ✓ | | Vern | |
| S 0.354 | +/- 0.010 | 0.351 | ✓ | | Vern | |
| T 0.063 | +/- 0.010 | 0.059 | ✓ | | Vern | |
| U | | | | | | |
| V | | | | | | |
| W | | | | | | |
| X | | | | | | |
| Y | | | | | | |

| | | | |
|------------------|----------------|---------------------|------------|
| Measured by: RAD | Audited by: BG | Prototype Approval: | N/A |
| Date: 07/05/08 | Date: 07-05-08 | Date: | N/A |
| Rev | Date | Change | Revised by |
| | | New Issue | KJ/RF |
| | | | Approved |